

Date: Thursday, 22/01/2009 2:10:53 PM  
 User: Melanie Fauteux

## Process Sheet

TUL MAR

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 90 DEGREE COVER PLATE  
 Job Number : 45076  
 Estimate Number : 13405  
 P.O. Number :  
 This Issue : 22/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : PB674300169  
 First Issue : / / Type : SMALL / MED FAB Drawing Number : B6743001 PAGE25  
 Previous Run : 41511 Drawing Revision : B1  
 Written By : Due Date : 29/01/2009 Qty: 16 Um: Each  
 Checked & Approved By : MF 09-01-22  
 Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

## Additional Product

Job Number:



SCRAP

Seq. #: Machine Or Operation: Description:

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 1.4234 sf(s)/Unit Total: 14.2338 sf(s)  
 6061-T6 Sheet 0.032" 110053 RB 9-1-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg B67-43001  
 Dwg Rev: B1 RB 9-1-26  
 Prog Rev: B1  
 \*\*\*\*grain direction along 9.144" \*\*\*\*  
 2-Deburr if necessary RB 9-1-26

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE RB 9-1-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 09/01/27 counter (x20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Bend as per Dwg B67-43001

SB 09/22/04 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counters*  
*SP 09/02/05 (x20)*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg B67-43001 *MI 04/05*

*SP 09/02*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

*SP 09/02*

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-69 PAR #: 09-011 Fault Category: EN/Design NCR: Yes ~~No~~ DQA: W Date: 09/02/12  
 Resolution: Documentation revision Disposition: W QA: N/C Closed: W Date: 09/02/12

NCR: <u>45076</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.02.11</u>	<u>8.0</u>	<u>PART DO NOT FIT RON ASSY. 20 parts RC Part Take Redesign</u>	<u>09.02.11</u>	<u>SURVEY DETECTED. WHY? @ EWG. TO ISSUE WORKING.</u>	<u>SAD</u> <u>09-02-12</u>	<u>09.02.12</u>	<u>09.02.12</u>	<u>09.02.12</u>
				<u>PARC</u>				

NOTE: Date & initial all entries

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Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

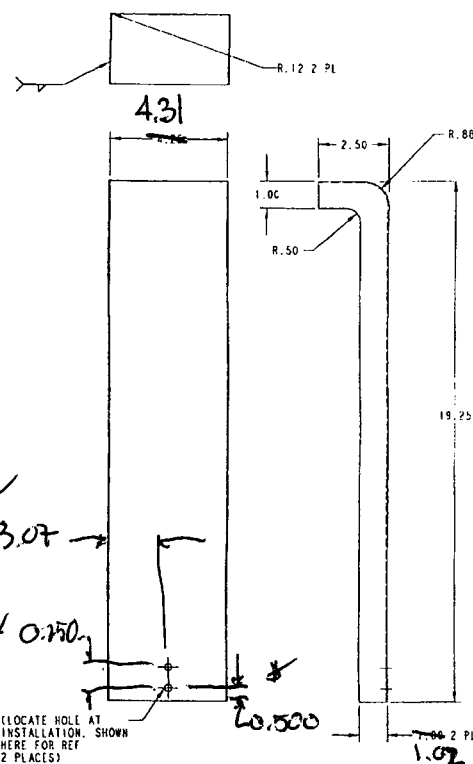
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

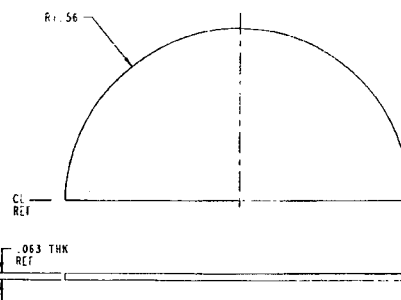


RELEASED

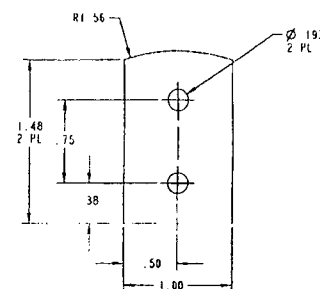


-69 90 DEGREE COVER PLATE

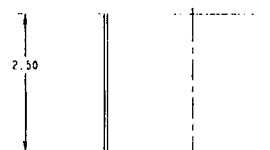
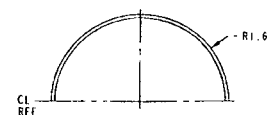
MATL: .032 THK, 6061-T6, QQ-A-250/11  
SCALE 0.500



⑧ -339 D-PAD TOP  
MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000



⑧ -193 D-PAD BASE  
MATL: .125 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000



⑥ -185 D-PAD BACK PLATE

MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 1.000

⑥ -189 D-PAD FACE

MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 1.000

PREMIER AVIATION, INC.  
2800 Aviation Parkway, Grand Prairie, Texas 75052

SIZE: 11x17  
DATE: 11/11/81  
REV: 1  
DISUV81 B67-43001 184  
SCALE: 25 = 1

ORIGINAL